

Date: Thursday, 27/11/2008 2:23:50 PM
User: Julie Dawson

Process Sheet

| | |
|--|---------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : CROSS BEAM |
| Job Number : 43811 | |
| Estimate Number : 11026 | |
| P.O. Number : | Part Number : D2764 |
| This Issue : 27/11/2008 S.O. No. : | Drawing Number : D2764 REV D |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : // Type : MACHINED PARTS | Drawing Revision : D |
| Previous Run : 33586 | Material : |
| Written By : | Due Date : 20/12/2008 Qty: 4 Um: Each |
| Checked & Approved By : <u>JWD 08-11-27</u> | |
| Comment : Est. D 00.08.14 Added note at step #1 EC | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|--------------------|-------------------------|
| 1.0 | M6061T6B1000X02500 | 6061-T6 Bar 1.00 x 2.50 |
|-----|--------------------|-------------------------|



Comment: Qty.: 4.2875 f(s)/Unit Total : 17.1499 f(s)

6061-T6 Bar 1.0" x 2.5"

Material: 1" X 2.5" 6061-T6 (QQ-A-200/8)

Batch No: M103039 10365 (1 PCS)

20 08 / 11 / 30

| | | |
|-----|----------|----------|
| 2.0 | BAND SAW | BAND SAW |
|-----|----------|----------|



Comment: BAND SAW

Cut Blanks: 48.5"

*** RUN D2796 WITH SAME PROG. ***

20 08 / 11 / 30

| | | |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1

Machine per Folio D2764

Deburr

H.A 08/12/02 20 08 / 11 / 30

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A 08/12/02 20 08 / 11 / 30

| | | |
|-----|-----|--------------|
| 5.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|




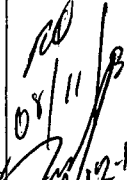
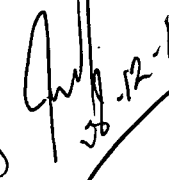

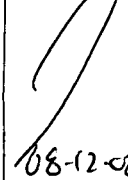


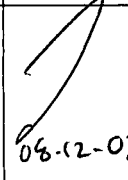
Comment: SECOND CHECK

JWD 08-12-03

(3)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D2764 PAR #: N/A Fault Category: Prod/Machined Parts NCR: Yes No DQA: D Date: 08/12/15
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: D Date: 08/12/15

| NCR: <u>43811</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-------------------|------|--|---|---|--|--|---|--|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 08.12. | 3 | TOOL DROPPED ON PART. DENT > 0.030". R.C: Tool was not properly positioned in the holder. Machine thought the tool was in place, during operation Machine malfunctioned |  | SCRAP PART. BEYOND DMG TOL. OF ICA/MMS No - Replace → Set up already tore down. |  08.12.02 |  08.12.15 |  |  08-12-02 |
| | | |  | | | |  |  08.12-02. |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 27/11/2008 2:23:50 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSS BEAM

Job Number: 43811

Part Number: D2764

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

910

08-12-09 (x3)

7.0

POWDER COATING

POWDER COATING



M109152



(3x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:10
320°F
2:40

m-1 08/12/10

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(3)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Fix 08/12/10

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 206

AS 08/12/11 (x3)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/11

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08/12/11

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|------------------------------------|-----------------|---------------------------|
| DART AEROSPACE LTD | | Work Order: 43811 |
| Description: Cross Beam | | Part Number: D2764 |
| Inspection Dwg: D2764/D2796 | Rev: D/C | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

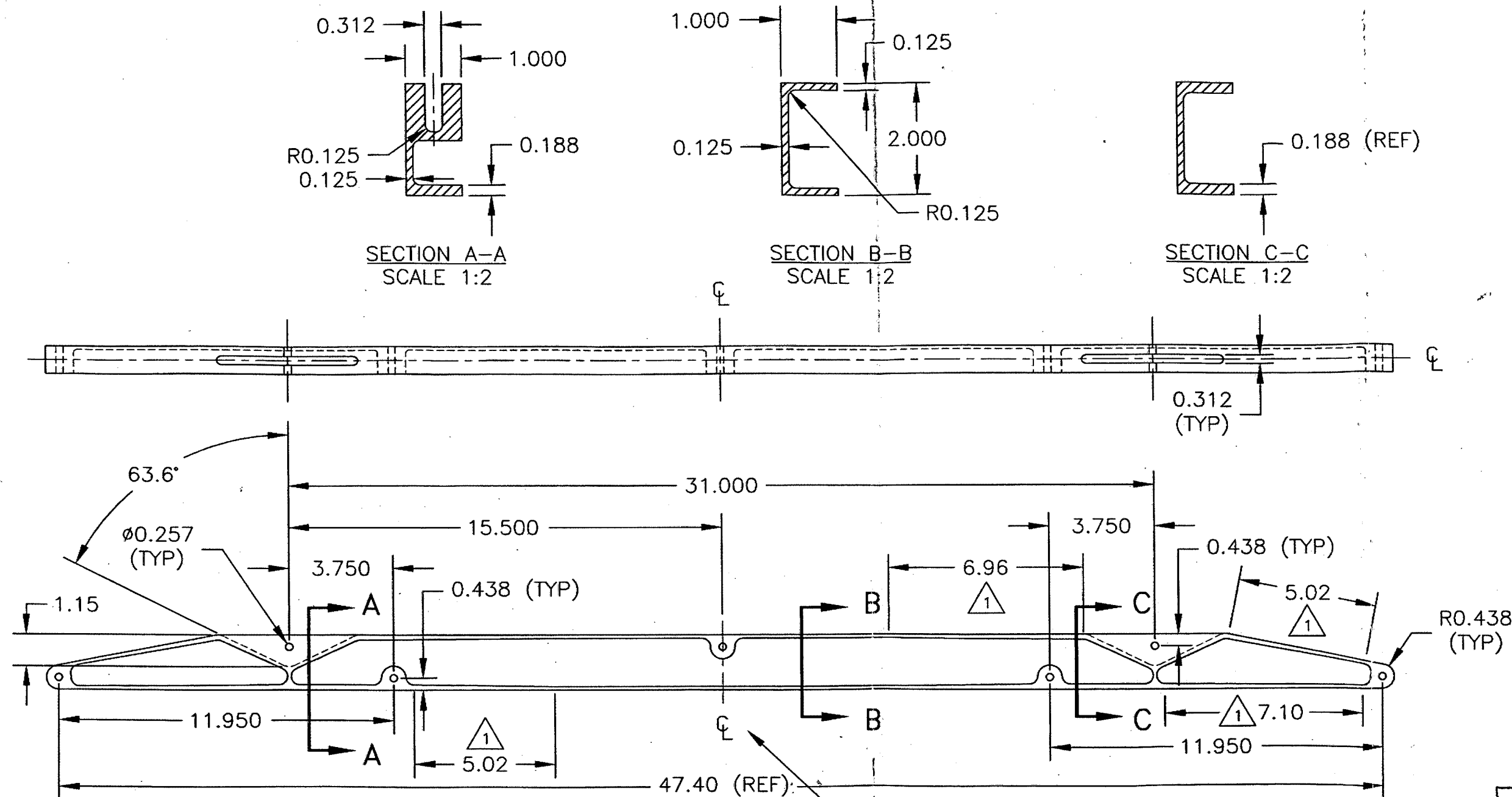
☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------------|--------|----------------------|----------|
| 0.600 | +/-0.010 | 0.600 | ✓ | | | |
| 1.090 | +/-0.010 | 1.090 | ✓ | | | |
| 0.312 | +/-0.010 | 0.312 | ✓ | | | |
| 1.000 | +/-0.010 | 1.000 | ✓ | | | |
| 0.125 | +/-0.010 | 0.122 | ✓ | | | |
| 0.188 | +/-0.010 | 0.187 | ✓ | | | |
| 0.125 | +/-0.010 | 0.124 | ✓ | | | |
| 2.000 | +/-0.010 | 1.999 | ✓ | | | |
| 0.438 | +/-0.010 | 0.441 | ✓ | | | |
| 5.02 | +/-0.030 | 5.02 | ✓ | | | |
| 11.950 | +/-0.010 | 11.950 | ✓ | | | |
| 3.750 | +/-0.010 | 3.750 | ✓ | | | |
| Ø0.257 | +0.006/-0.001 | Ø0.263 | ✓ | | | |
| 0.438 | +/-0.010 | 0.444 | ✓ | | | |
| 47.40 | +/-0.030 | 47.40 | ✓ | | | |
| 31.000 | +/-0.010 | 31.000 | ✓ | | | |
| 15.500 | +/-0.010 | 15.500 | ✓ | | | |
| 1.15 | +/-0.030 | 1.155 | ✓ | | | |
| R0.438 | +/-0.010 | R0.438 | ✓ | | | |
| | | | | | | |
| | | | | | | |

| | | |
|-------------------------|--------------------------------|--------------------------------|
| Measured by: B.A | Audited by: [Signature] | Prototype Approval: N/A |
| Date: 08/12/02 | Date: 08-12-03 | Date: N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 07.01.17 | New Issue | KJ/JLM | |

[Signature]



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43811

RELEASED
98.11.13 KE

EFFECTIVE DEOS

| | |
|------|--|
| 9126 | |
| | |

PART IS SYMMETRIC
ABOUT THIS CENTER LINE

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225/8) KE
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 98.12.03
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 T3R A 1031
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

△ TAPERED WALL THICKNESS FROM 0.188 TO 0.125 OVER INDICATED LENGTH

| | | |
|------------------|---------------------|---|
| D | 98.11.09 | TAPERED WALLS ADDED |
| C | 98.09.01 | MACHINED PART WAS BOX BEAM |
| B | 98.06.17 | ADD LARGE HOLES & STIFFENER |
| A | 98.04.14 | NEW ISSUE |
| DESIGN KE | DRAWN BY KE | DART DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED SH | APPROVED DS | DRAWING NO. D2764 REV. D SHEET 1 OF 1 |
| DATE 98.11.09 | TITLE CROSS BEAM | SCALE 1:4 |

1900 F 15.00